

Date: Wednesday, 1/4/2006 2:37:16 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 25395C	
Estimate Number : 10354	
P.O. Number : N/A	Part Number : D2322
This Issue : 1/4/2006 S.O. No. : N/A	Drawing Number : D2322 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 25089C	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/25/2006
Checked & Approved By : <u>SEE ABOVE USER</u>	Qty: <u>30</u> Um: Each
Comment : Est Rev:A New Issue 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2132 sf(s)/Unit Total: 4.2630 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2322
 Batch: M19059

J.L 06.02.01 30

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500")

J.L 06.02.01 30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2322, use stack of 15

J.L 06.02.01 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.02.01 20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Eo 06/02/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *JD* Date: 06/02/01

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-02-01	3	- 10 parts are scrapped - .250 dimension $\pm .005$ ranges between .235 to .260	<i>JD</i> 06-02-01	destroy & replace	JL 06-02-01	<i>JD</i> 06-02-01	<i>JD</i> 06-02-01	<i>JD</i> 06-02-01

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 25395C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

ml 06/02/03 (20)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2322

SB 06/02/06 (20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ja 02-06 20

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/06 20

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ja 02-08 20

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/02/08 (20)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

LD 06/02/04

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<i>25395C</i>
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

x

[illegible]

Measured by:	J.L	Audited by:	En	Prototype Approval:	N/A
Date:	06-02-01	Date:	06-02-01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	

DART

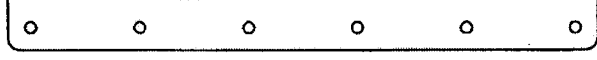


DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2322	REV. C SHEET 1 OF 1
DATE 98.09.29	TITLE STEP SPACER		
A	94.10.14	NEW ISSUE	
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	
SCALE 1:2			

RELEASED
18.10.98 DS

UNDER REVIEW

01.03.15 GP
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE
OK GP 04.11.9

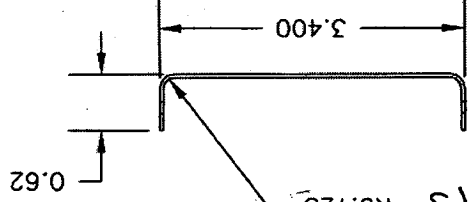
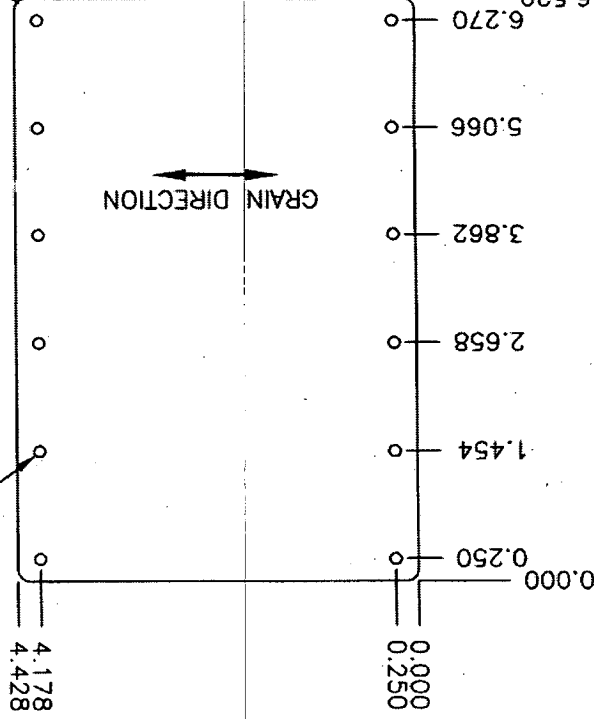


Ø0.128 (TYP 12 PLACES)

Ø0.125 (TYP 4 PLACES)
KE 04.05.00

GRAIN DIRECTION

FLAT LAYOUT



6.520
6.270
5.066
3.862
2.658
1.454
0.250
0.000
0.000
0.250
4.178
4.428
GRAIN DIRECTION
FLAT LAYOUT
Ø0.125 (TYP 4 PLACES)
Ø0.128 (TYP 12 PLACES)
OK GP 04.11.9
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE
01.03.15 GP
UNDER REVIEW
RELEASED
18.10.98 DS
DART
QA COPY ISSUED

MATERIAL: 2024-T3 (00-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED